

Date: Friday, 9/21/2007 1:17:06 PM  
 User: Kim Johnston

## Process Sheet

|                       |  |                       |                  |                              |  |  |
|-----------------------|--|-----------------------|------------------|------------------------------|--|--|
| Customer              | : CU-DAR001 Dart Helicopters Services  |                       | Drawing Name     | : WEARSHOE                   |  |  |
| Job Number            | : 34806  |                       | Part Number      | : D35645                     |  |  |
| Estimate Number       | : 12786  |                       | Drawing Number   | : D3564 REV D                |  |  |
| P.O. Number           | : N/A  |                       | Project Number   | : N/A                        |  |  |
| This Issue            | 9/21/2007  | S.O. No. : N/A        | Drawing Revision | : D                          |  |  |
| Prsht Rev.            | : NC   |                       | Material         | : N/A                        |  |  |
| First Issue           | 9/21/2007  | Type : SMALL /MED FAB | Due Date         | : 10/5/2007 Qty: 30 Um: Each |  |  |
| Previous Run          | : 33802  |                       |                  |                              |  |  |
| Written By            |  |                       |                  |                              |  |  |
| Checked & Approved By |  |                       |                  |                              |  |  |
| Comment               | Est Rev:A New Issue 07-03-08 ec<br>Est Rev:B As per Rev C 07-07-09 JLM<br>Est Rev:C As per Rev D 07-09-09 JLM Verified By:EC |                       |                  |                              |  |  |

## Additional Product

Job Number:



| Seq. #: | Machine Or Operation: | Description :   |
|---------|-----------------------|---|
| 1.0     | M304S16GA             | 304/316 .063 Sheet<br><br>$x23 = 25.5217 \text{ sf}$ $x13 = 7.7693$<br>Comment: Qty: 1.1099 sf(s)/Unit      Total: 33.2955 sf(s)<br>M304S16GA Stainless steel sheet 0.063" thick<br>Batch: m105 824      HB07-10-4      m105130 |
| 2.0     | WATER JET             | FLOW WATER JET<br><br>Comment: FLOW WATER JET<br>1-Cut as per Dwg D3564<br>Dwg Rev: C      HB 07-10-4<br>Prog Rev: C<br><br>2-Deburr if necessary   |
| 3.0     | QC2                   | INSPECT PARTS AS THEY COME OFF MACHINE<br><br><del>HB 07-10-4</del><br>Comment: INSPECT PARTS AS THEY COME OFF MACHINE  |
| 4.0     | QC8                   | SECOND CHECK<br><br><del>HB 07-10-4</del><br>Comment: SECOND CHECK  |
| 5.0     | BRAKE NC              | NC BRAKE<br><br>Comment: NC BRAKE<br>Deburr if necessary<br>Form on Brake as per Dwg D3564 using Jigs DT and DT<br><del>8179 - 8155</del><br>Form Joggle as per Dwg D3564 on brake using Jig DT      8157                       |

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA:  Date: 07/18/19  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries

Date: Friday, 9/21/2007 1:17:06 PM  
User: Kim.Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARSHOE

Job Number: 34806

Part Number: D35645

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Ensure joggle as per dwg D3429

coaters  
Dr 07/10/17 (X30)

7.0 POWDER COATING

POWDER COATING



M104846



(30x)

Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

mf 07/10/18

8.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



AS



(30x)

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

07-10-18

9.0 PACKAGING 1

PACKAGING RESOURCE #1



(30x)

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

FP 15

mf 07/10/18

10.0 QC21

FINAL INSPECTION/W/O RELEASE



(30)

Comment: FINAL INSPECTION/W/O RELEASE

mf 07/10/19

Job Completion



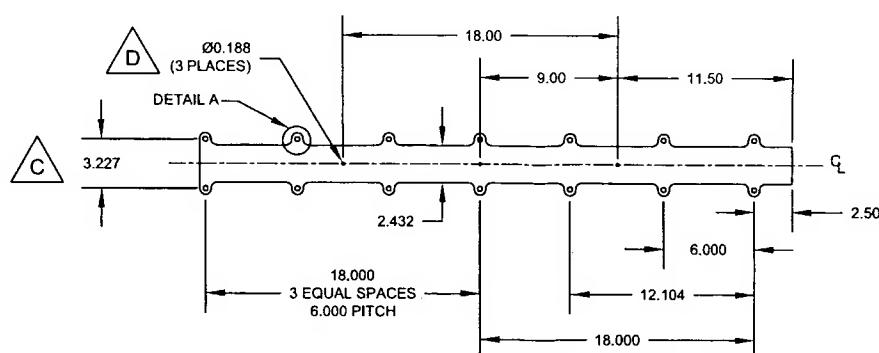
mf 07/10/19

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

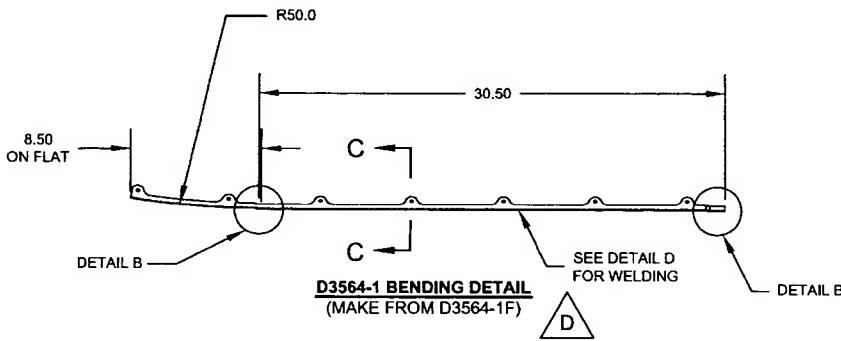
NOTE: Date & initial all entries



**D3564-1F FLAT PATTERN**

RELEASED

07.09.04 off



**D3564-1 BENDING DETAIL**  
(MAKE FROM D3564-1F)

**D3564-3 BENDING DETAIL**  
(MAKE FROM D3564-1F)

D3564-1/-3/-5/-7/-9/-11/-13/-15 WEARPLATE NOTES:

1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)  
(REF DART MATERIAL SPEC M304516GA)

2) FINISH: POWDER COAT GREY SANTEX (REF 4.3.5.6) PER DART QSI 005 4.3

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX

6) IDENTIFICATION: NONE

7) WEIGHT: SEE TABLE IN ZONE A3

8) WELD PER DART QSI 004

9) SEE PG 3 FOR SECTIONS AND DETAILS

10) PARTS ARE SYMMETRIC ABOUT C

UNCONTROLLED SUBJECT TO A  
WITHOUT WORK  
NO. 34

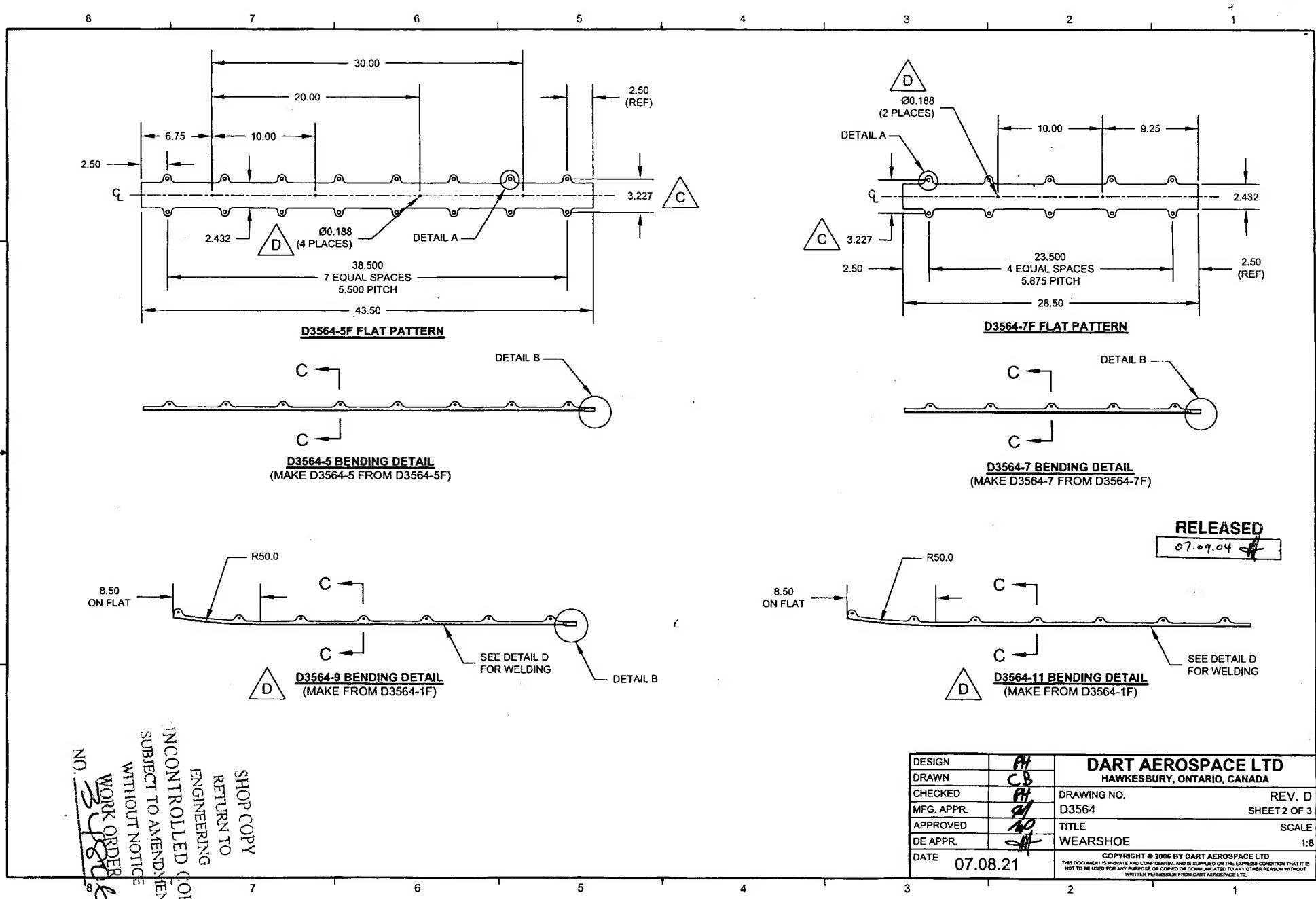
SHOP CO.  
RETURN  
ENGINEER

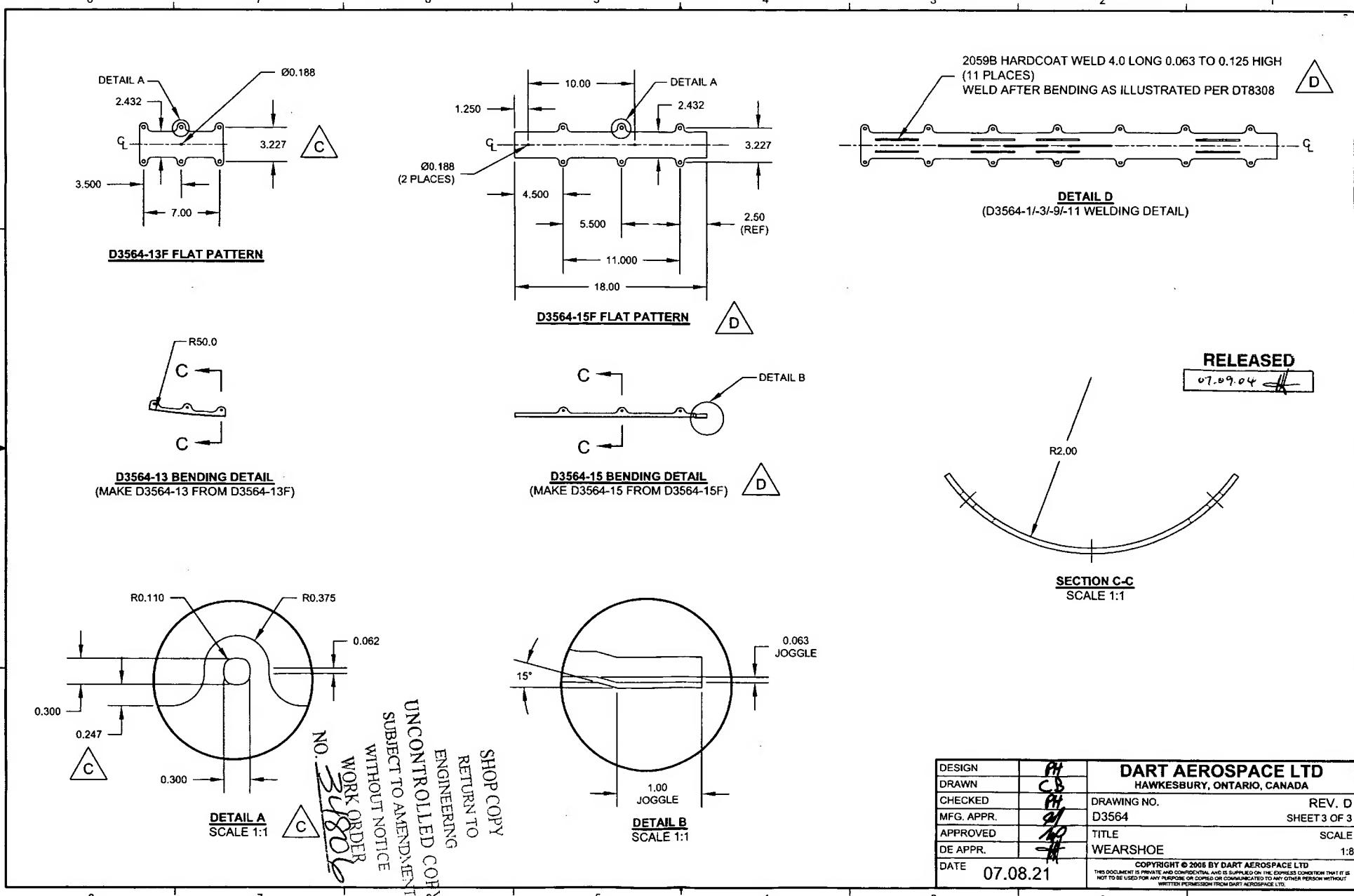
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 3480

| <u>WEIGHTS:</u> |          |
|-----------------|----------|
| D3564-1         | 1.85 lbs |
| D3564-3         | 1.85 lbs |
| D3564-5         | 1.93 lbs |
| D3564-7         | 1.26 lbs |
| D3564-9         | 1.85 lbs |
| D3564-11        | 1.85 lbs |
| D3564-13        | 0.38 lbs |
| D3564-15        | 0.80 lbs |

|            |   |   |              |          |  |  |
|------------|---|---|--------------|----------|--|--|
| D          | UPDATE DRAWING TEMPLATE;<br>CHANGE ALL (TYP X PL)S TO (X PLACES);<br>PG1 A8: UPDATE NOTES;<br>PG1 A8, PG3 B5,C5: ADD D3564-15;<br>PG1 B6,B3: D3564-1/3 WAS ONE FIGURE;<br>PG2 A7,A3: D3564-9/11 WAS ONE FIGURE;<br>PG2 A7,A3: D3564-9/11 WAS ON PG1;<br>PG3 B8,C8: D3564-13 WAS ON PG2;<br>PG3 D2: WELDING DETAIL WAS ON PG1<br>PG3 A5,7,B2: RELOCATE DETAILS AND SECTION;<br>PG3 A5,7,B2: INCREASE DETAIL AND SECTION SIZE | CB  | 07.08.21     |          |  |  |
|            | MOVE TAB OUTBOARD, DETAIL A   |   | PH           | 07.04.17 |  |  |
|            | ADD AMS 5513 AND AMS 5524   |   | PH           | 07.03.20 |  |  |
|            | NEW ISSUE   |   | PH           | 06.12.18 |  |  |
| REV.       | DESCRIPTION   | BY  | DATE         |          |  |  |
| DESIGN     | <i>PH</i>   | <b>DART AEROSPACE LTD</b><br>HAWKESBURY, ONTARIO, CANADA  |              |          |  |  |
| DRAWN      | <i>CB</i>   |   |              |          |  |  |
| CHECKED    | <i>PH</i>   | DRAWING NO.   | REV. D       |          |  |  |
| MFG. APPR. | <i>SI</i>   | D3564   | SHEET 1 OF 3 |          |  |  |
| APPROVED   | <i>SI</i>   | TITLE   | SCALE        |          |  |  |
| DE APPR.   | <i>SI</i>   | WEARSHOE  | 1:8          |          |  |  |
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|            |          |                             |
|------------|----------|-----------------------------|
| DESIGN     | PH       | DART AEROSPACE LTD          |
| DRAWN      | CD       | HAWKESBURY, ONTARIO, CANADA |
| CHECKED    | PH       | DRAWING NO. D3564           |
| MFG. APPR. | SI       | REV. D                      |
| APPROVED   | AD       | SHEET 3 OF 3                |
| DE APPR.   | SI       | TITLE                       |
| DATE       | 07.08.21 | SCALE 1:8                   |

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|                              |              |             |
|------------------------------|--------------|-------------|
| DART AEROSPACE LTD           | Work Order:  | 34806       |
| Description: WEAR SHOE       | Part Number: | D3564-5     |
| Inspection Dwg: D3564-5 Rev: |              | Page 1 of 1 |

# FIRST ARTICLE INSPECTION CHECKLIST

## First Article Prototype

|                        |                       |                                |
|------------------------|-----------------------|--------------------------------|
| Measured by: <u>RB</u> | Audited by: <u>EN</u> | Prototype Approval: <u>✓/✓</u> |
| Date: <u>07-10-4</u>   | Date: <u>2/10/05</u>  | Date: <u>✓/✓</u>               |

| Rev | Date | Change    | Revised by | Approved |
|-----|------|-----------|------------|----------|
| A   |      | New Issue | KJ/JLM     |          |